

Date: Tuesday, 10/03/2009 10:51:05 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : RIB ASSY (BASKET END)
Job Number : 46390	
Estimate Number : 13666	
P.O. Number :	Part Number : D3825041
This Issue : 10/03/2009 S.O. No. :	Drawing Number : D3825 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 46087	Material :
Written By :	Due Date : 16/03/2009 Qty: 6 Um: Each
Checked & Approved By : <u>JUD 09.03.10</u>	
Comment : Est Rev:A 08-12-01 new issue DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D23273	Spacer Bushing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Spacer Bushing

Batch: B39560 → 6x

dy 09/03/20

2.0	D37591	Bushing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bushing

Batch: B45890 → 6x

dy 09/03/20

3.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
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Comment: Qty.: 2.2313 f(s)/Unit Total : 13.3875 f(s)

304 SQ Tube .75x.75x.065W

batch: M110969

SAD 09-03-18

6

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1- cut D3825-1 rib as per dwg D3825 ✓

2- drill hole (3/16") in D3825-1 using DT9438 jig and open to finish size as per dwg D3825 ✓

3- c'sink hole as per dwg ✓

4- remove identification markings ✓

5- deburr ✓

SAD 09-03-18

⑥

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/03/2009 10:51:05 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIB ASSY (BASKET END)

Job Number: 46390

Part Number: D3825041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



20903.19 (6)



Comment: INSPECT WORK TO CURRENT STEP

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- weld D2327-3 spacer bushing and D3759-1 bushing as per dwg D3825 *LD*

A/R ER316 S.S. Rod Batch: *M108775*

2- grind bushing weld flush where indicated on dwg D3825

3- deburr if necessary

LD 09/03/20 (6x)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-03-23 (6)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 09-03-23 (6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Basket*

PD 09-03-23 (6)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/24 JA

Job Completion



MF 09-03-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

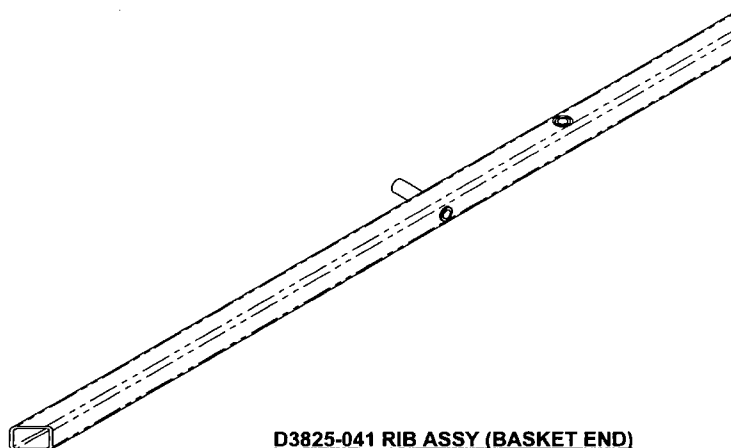
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3825-041	RIB ASSEMBLY (BASKET END)
2	1	D2327-3	SPACER BUSHING
3	1	D3759-1	BUSHING
4	1	D3825-1	RIB



D3825-041 RIB ASSY (BASKET END)

NO. **10570**
 WORK ORDER
 WITHOUT NOTICE
 UNCONTROLLED COPY
 ENGINEERING
 RETURN TO

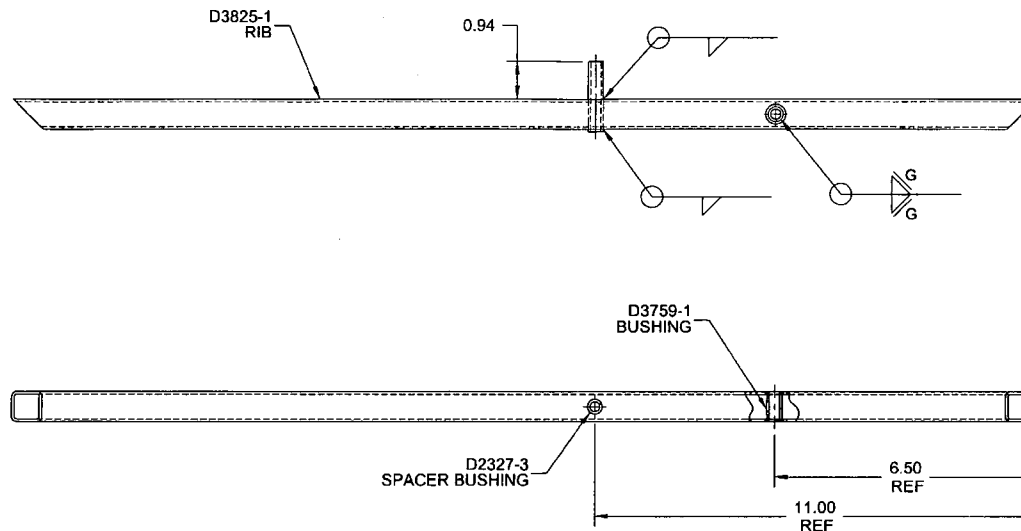
- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 1.22 lbs
 8) WELDING: PER DART QSI 004

RELEASED
 08/11/18

A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.23		

DART AEROSPACE LTD
 HAWKESBURY, ONTARIO, CANADA
 DRAWING NO. **D3825**
 TITLE **RIB ASSY (BASKET END)**
 REV. A
 SHEET 1 OF 3
 SCALE
 NTS

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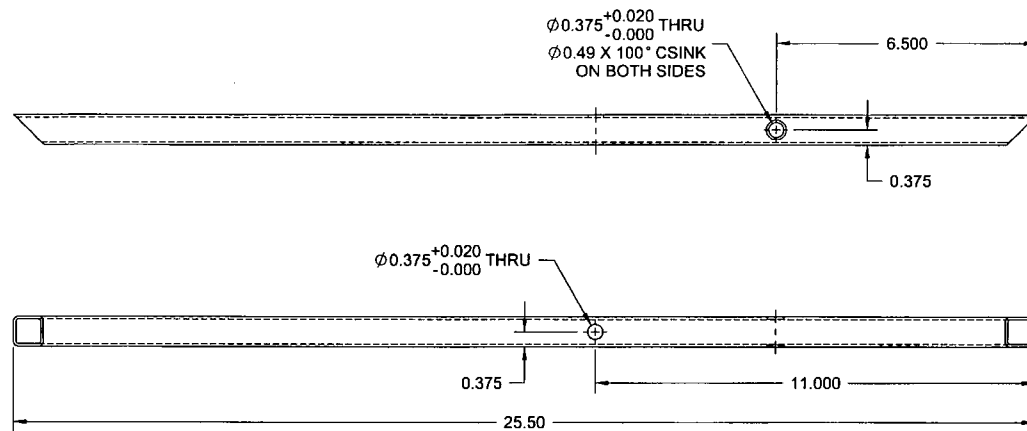


D3825-041 RIB ASSY (BASKET END)

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 16390

RELEASED
08/11/18 NW

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. A
MFG. APPR.	M	D3825	SHEET 2 OF 3
APPROVED	W	TITLE	SCALE
DE APPR.	W	RIB ASSY (BASKET END)	
DATE	08.09.23	NTS	
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D3825-1 RIB

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 46370

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.18 lbs

RELEASED
08/11/13

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3825	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET END)	NTS
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